



# Work Order ID 84321

**\*84321\***

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Item ID: D2281

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Jack Saddle

Start Date: 5/09/12 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 5/14/12 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr N/A								
140		0.00							
<b>*140*</b>	NC BRAKE								
Brake NC	Memo	0.00				10			
Brake NC	Form as per D2281 using D2281-T2								
150		0.00							
<b>*150*</b>	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00				10			
Quality Control									

8/26/14

W/M 10-05-14

# Work Order ID 84321

**\*84321\***

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Item ID: D2281 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Jack Saddle  
Start Date: 5/09/12 Start Qty: 10.00 **\*10\*** Cust Item ID:  
Required Date: 5/14/12 Req'd Qty: 10.00 **\*10\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <b>QA</b>	0.00							
<b>*160*</b>									
Packaging	Memo	0.00				10		54	12-5-14
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

12/5/15  
MF  
12-05-15

# Picklist Print

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Work Order ID: 84321

Parent Item: D2281

Parent Item Name: Jack Saddle

Start Date: 5/09/12

Required Date: 5/14/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM  
IPP: rev B 06.07.17 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA 304SS sheet .080		Purchased	No			100	sf	98.5400	0.125	1.3157895			

Location

Loc Qty

Loc Code

MAT020

98.54

117933

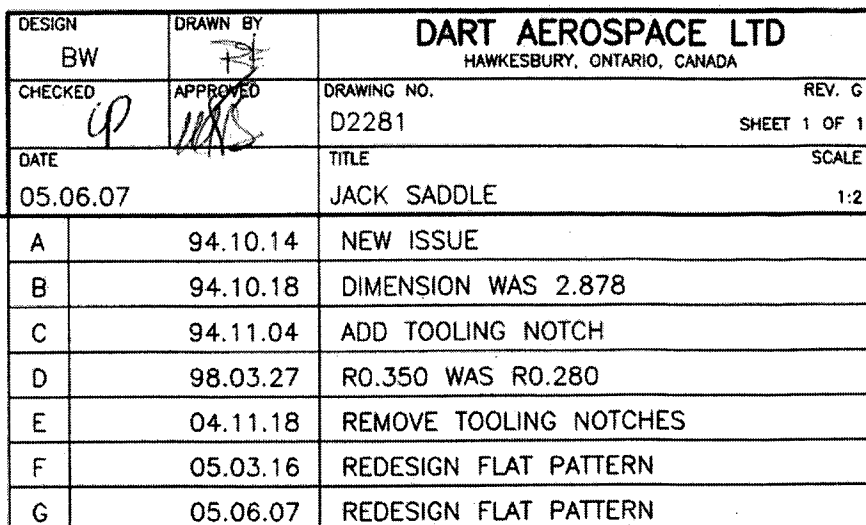
6.6

119276

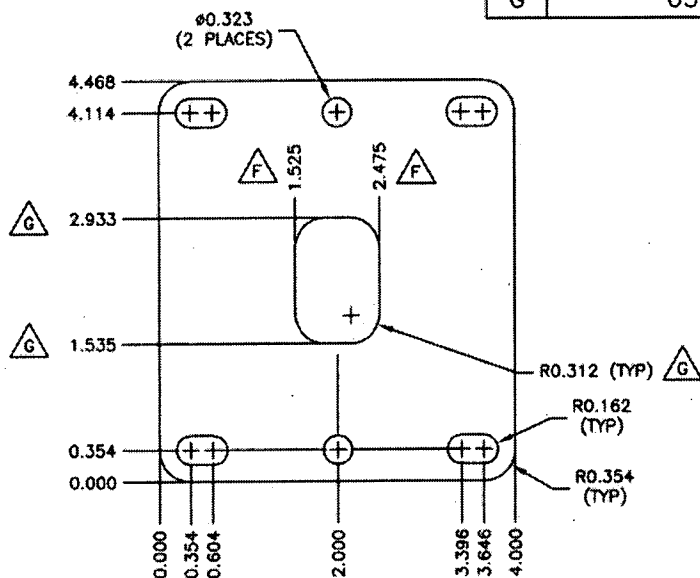
91.94

119276

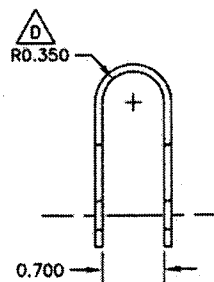
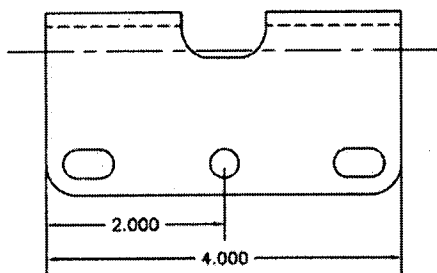
JM  
12-5-9



05/08/11



## FLAT LAYOUT



- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 84321
<b>Description:</b> Jack Saddle		<b>Part Number:</b> D2281
<b>Inspection Dwg:</b> D2281	<b>Rev:</b> G	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.472	✓		vern	HB-02
4.114	+/-0.010	4.113	✓		vern	HB-02
2.933	+/-0.010	2.935	✓		vern	HB-02
1.535	+/-0.010	1.536	✓		vern	HB-02
0.354	+/-0.010	0.354	✓		vern	HB-02
0.354	+/-0.010	0.353	✓		vern	HB-02
0.604	+/-0.010	0.605	✓		vern	HB-02
2.000	+/-0.010	1.996	✓		vern	HB-02
3.396	+/-0.010	3.389	✓		vern	HB-02
3.646	+/-0.010	3.638	✓		vern	HB-02
4.000	+/-0.010	4.001	✓		vern	HB-02
1.525	+/-0.010	1.529	✓		vern	HB-02
2.475	+/-0.010	2.474	✓		vern	HB-02
Ø0.323	+0.006/-0.001	0.326	✓		vern	HB-02
0.080	+/-0.010	0.074	✓		vern	HB-02

<b>Measured by:</b> Jm/	<b>Audited by:</b> nln	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12-5-9	<b>Date:</b> 12-05-10	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	